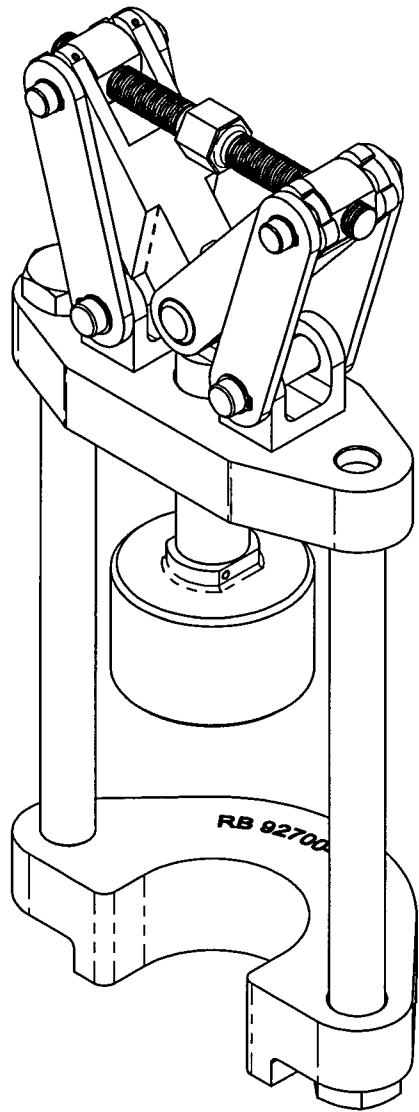
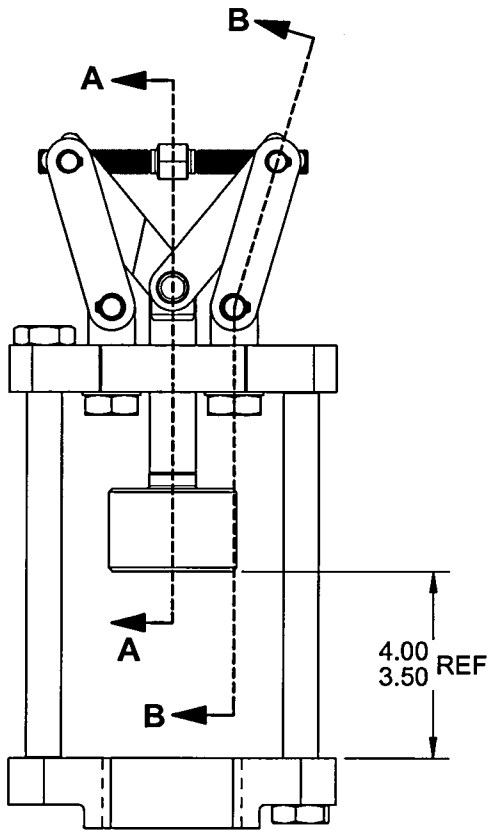
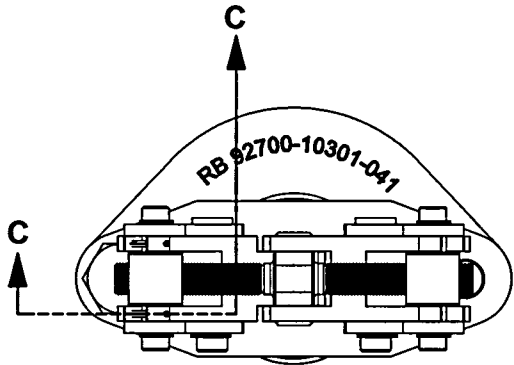


ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10301-041-1	PULLER PLATE
-2	2	RB 92700-10301-041-2	ROTATION PIN
-3	2	RB 92700-10301-041-3	BOLT
-4	1	RB 92700-10301-041-4	BASE
-5	1	RB 92700-10301-041-5	PUSHER ASSEMBLY
-8	1	RB 92700-10301-041-8	LINKAGE 1
-9	1	RB 92700-10301-041-9	LINKAGE 2
-10	4	RB 92700-10301-041-10	LINKAGE 3
-11	1	RB 92700-10301-041-11	LEFT HAND LINKAGE PIN
-12	1	RB 92700-10301-041-12	RIGHT HAND LINKAGE PIN
-13	2	RB 92700-10301-041-13	LINKAGE PIN
-14	1	RB 92700-10301-041-14	LINKAGE SCREW
15	2	McMaster#91922A312 OR EQUIV.	STEEL WASHER 0.77" ID. X 1.25" OD.
16	2	McMaster#92373A149 OR EQUIV.	SS SPRING PIN 3/32" DIA. X 1" LG.
17	2	McMaster#93839A840 OR EQUIV.	STEEL THIN HEX NUT 3/4"-16 X 27/64" HEIGHT.
18	1	McMaster#97395A821 OR EQUIV.	SS DOWEL PIN 5/8" DIA. X 1-1/2" LG.
19	4	McMaster#98410A119 OR EQUIV.	STEEL EXTERNAL RETAINING RING FOR 7/16" OD.
20	2	McMaster#98410A122 OR EQUIV.	STEEL EXTERNAL RETAINING RING FOR 1/2" OD.



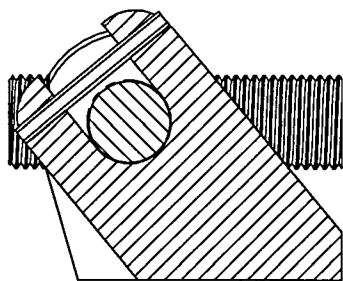
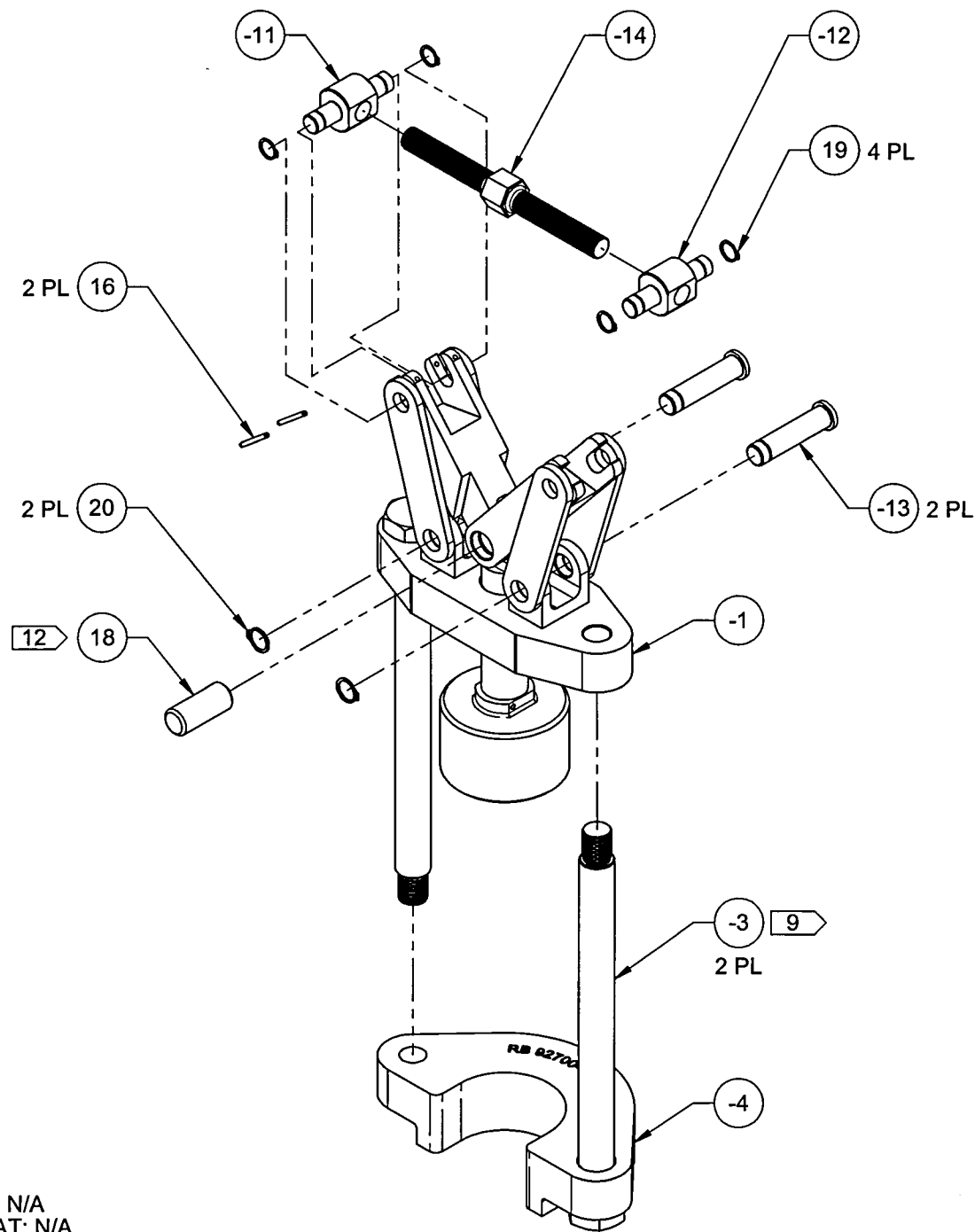
RB 92700-10301-041 PULLER ASSEMBLY

13

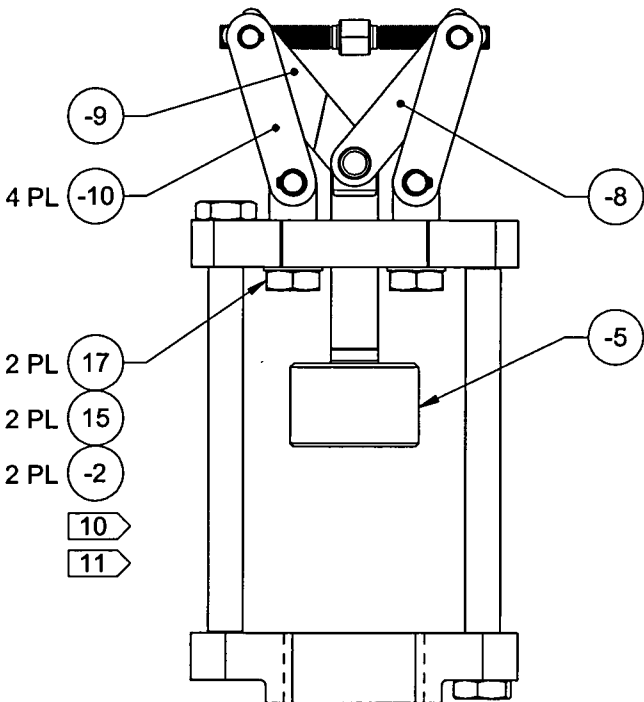
NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

A	NEW ISSUE	18-704	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>MZ</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 1 OF 16
APPROVED	<i>MZ</i>	TITLE	SCALE
DATE 10/24/2018		PULLER ASSEMBLY	NTS
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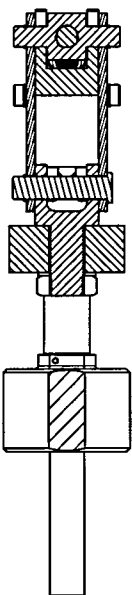
8 7 6 5 4 3 2 1



SECTION C-C



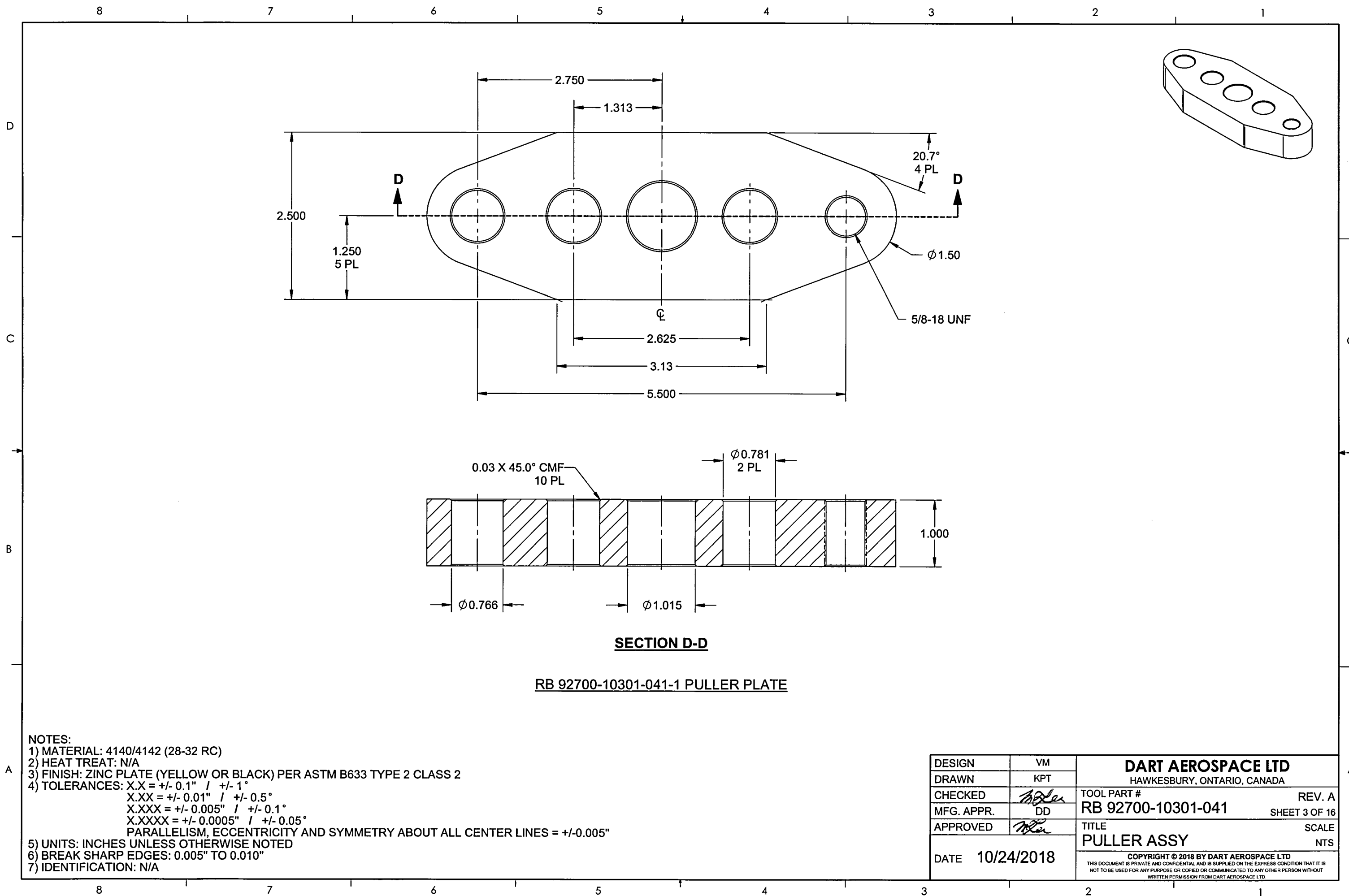
SECTION A-A



SECTION B-B

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN, ENSURE ALL COMPONENTS MOVE FREELY
 - 9) INSTALL ITEM -3 HAND TIGHT
 - 10) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM -2 THEN ASSEMBLE WITH ITEM 15 AND REMOVE EXCESS
 - 11) TORQUE ITEM 17 TO 600 IN-LBS
 - 12) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 18 WITH ITEMS -5 AND REMOVE EXCESS
 - 13) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

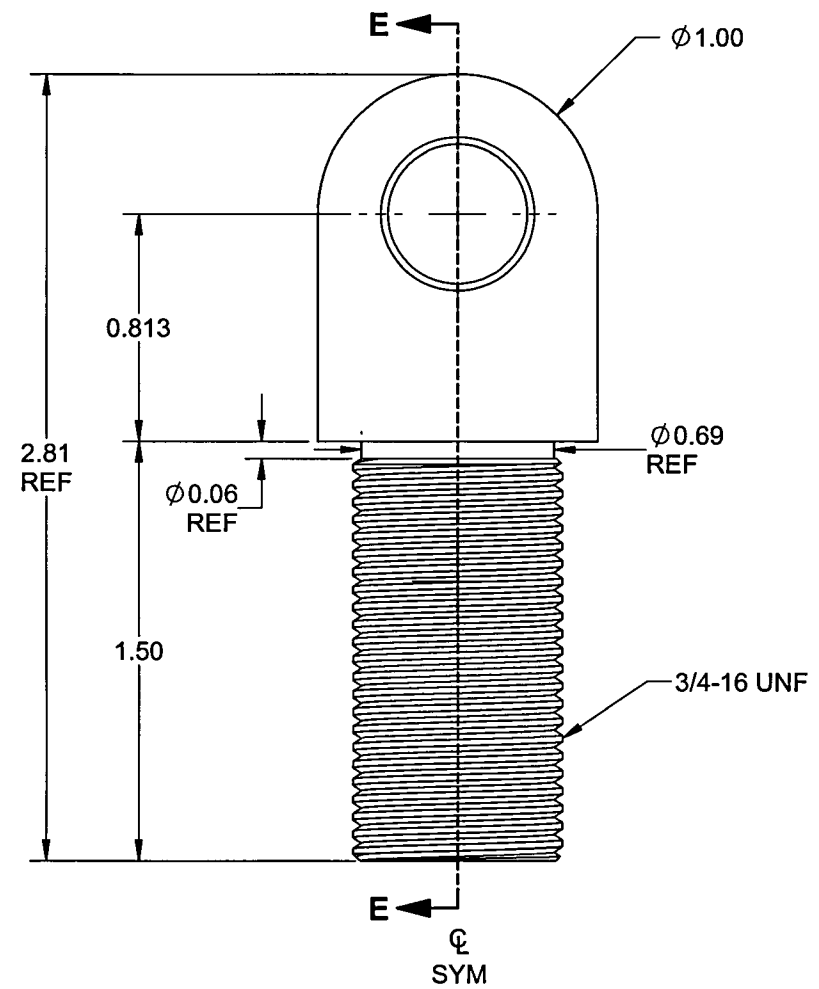
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 2 OF 16
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE 10/24/2018		PULLER ASSEMBLY	NTS
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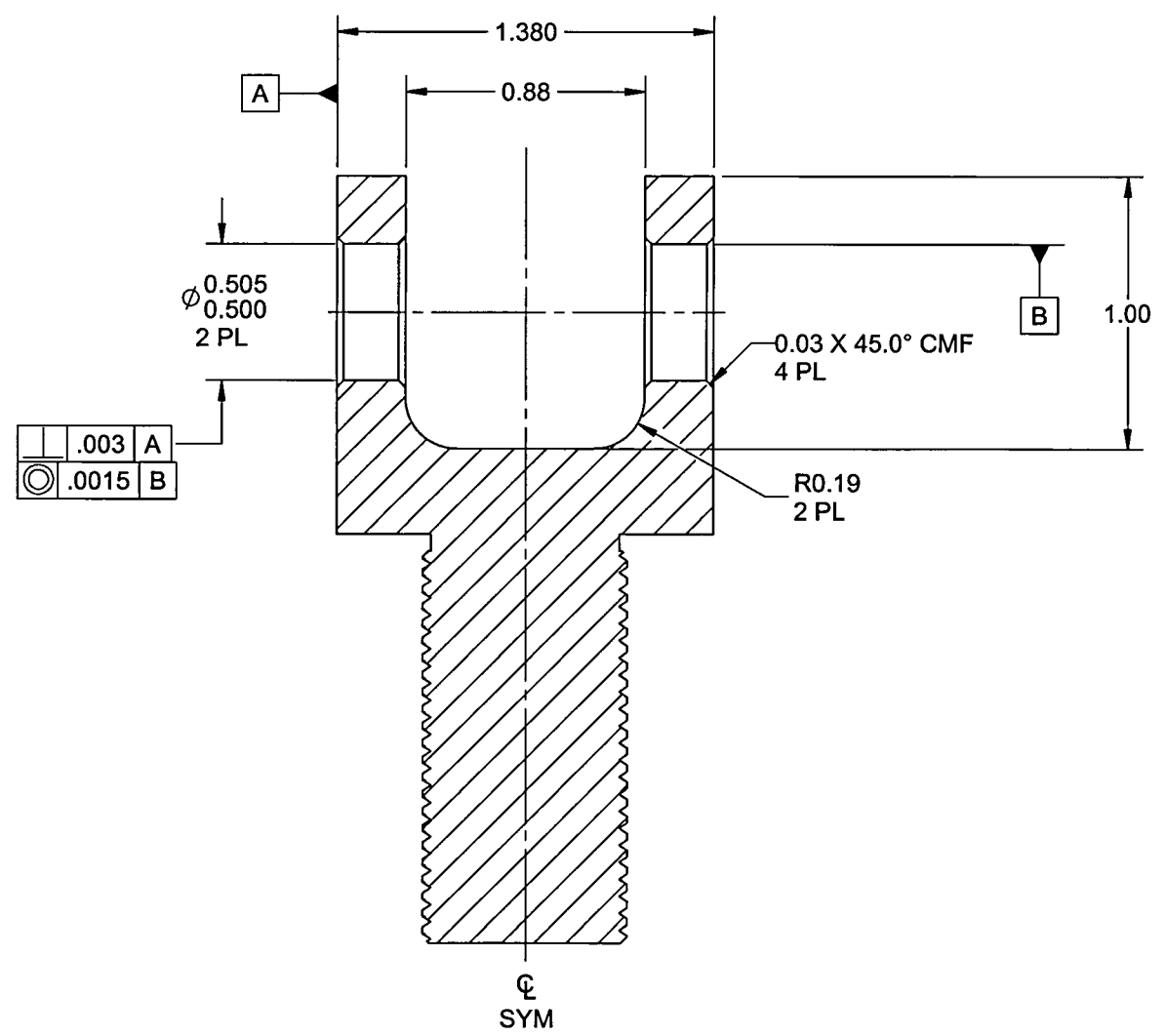
SECTION D-D
RB 92700-10301-041-1 PULLER PLATE

NOTES:
1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

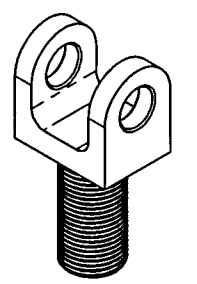
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 3 OF 16
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE 10/24/2018		PULLER ASSY	NTS
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RB 92700-10301-041-2 ROTATION PIN

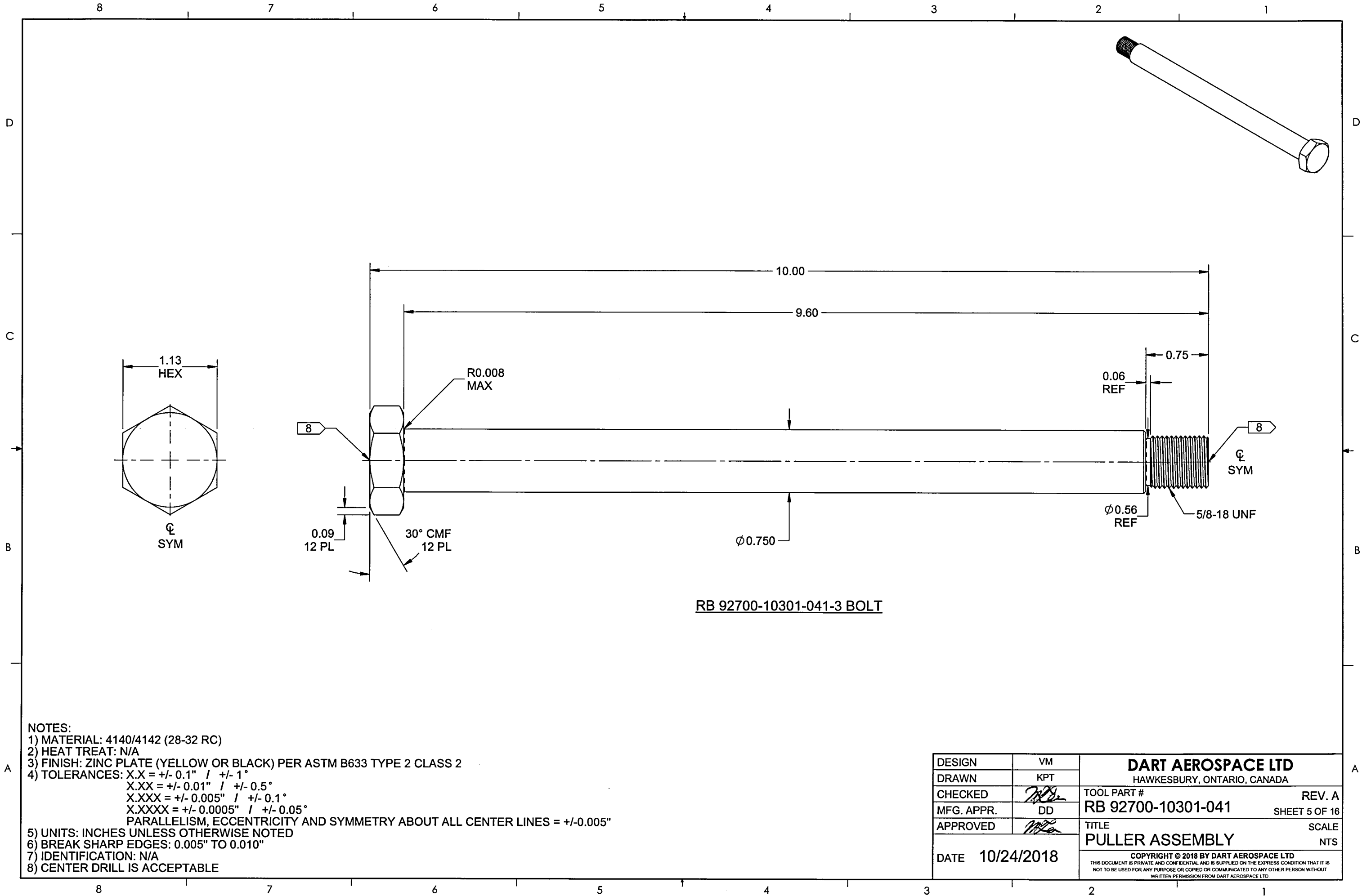


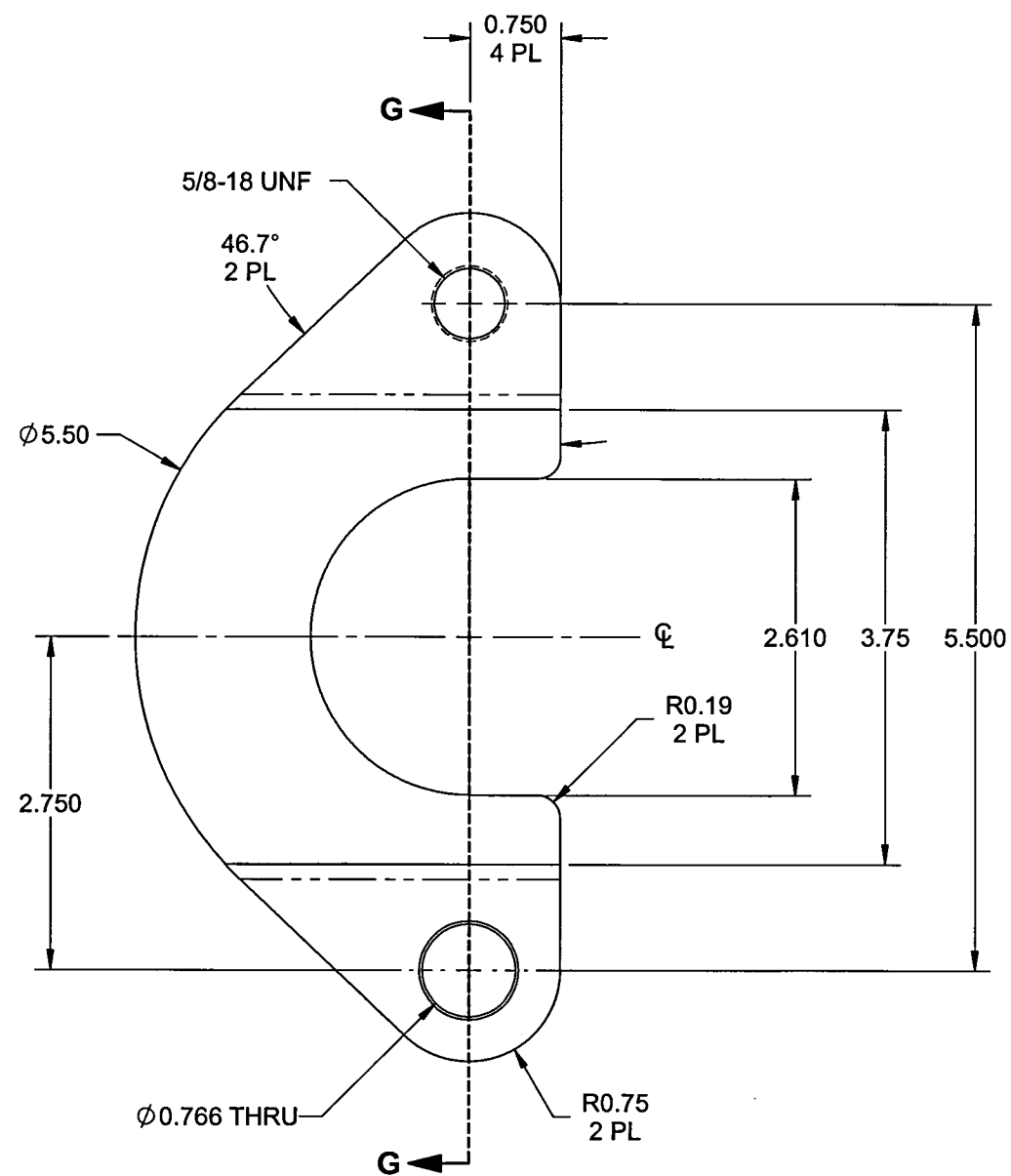
SECTION E-E



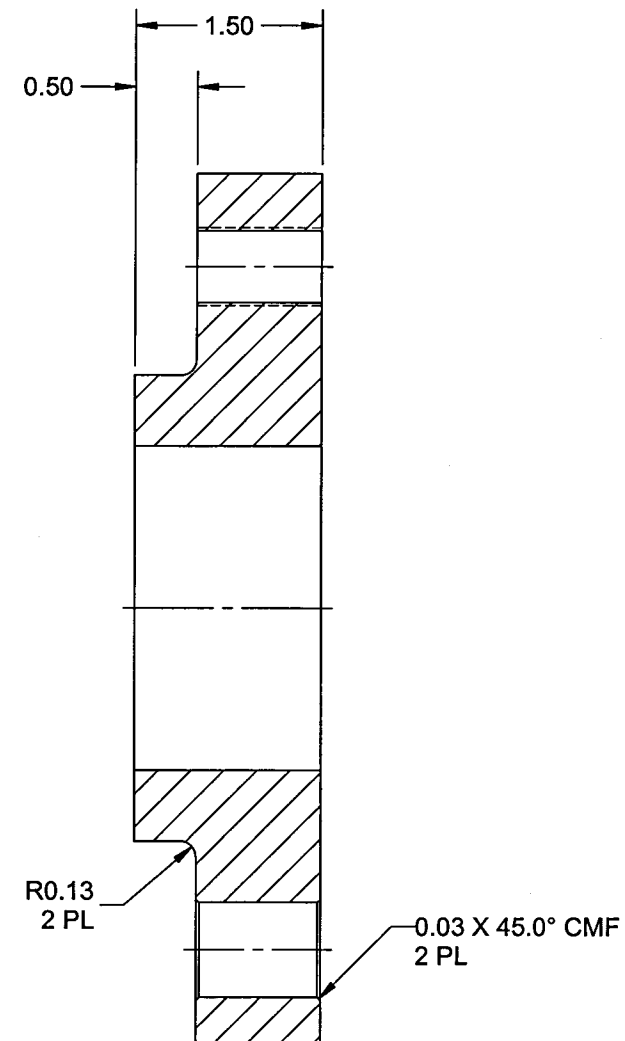
- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 4 OF 16
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE 10/24/2018		PULLER ASSY	NTS
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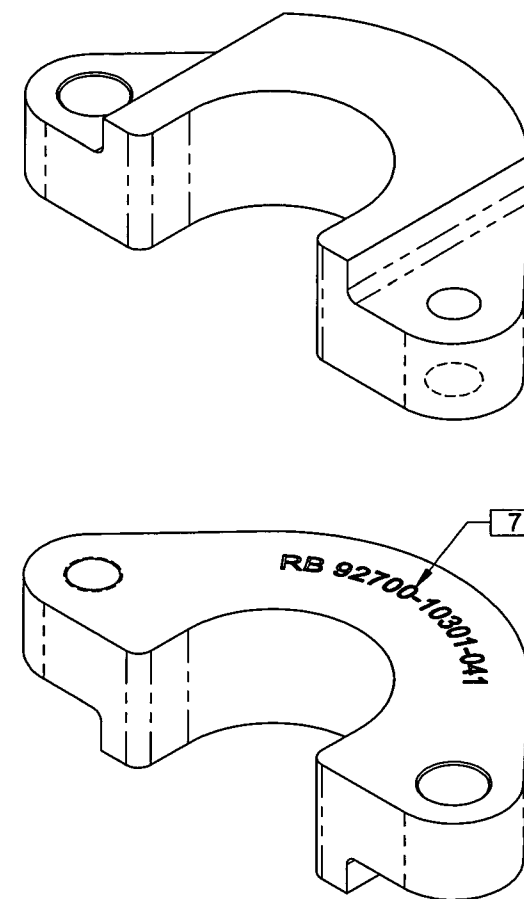




RB 92700-10301-041-4 BASE



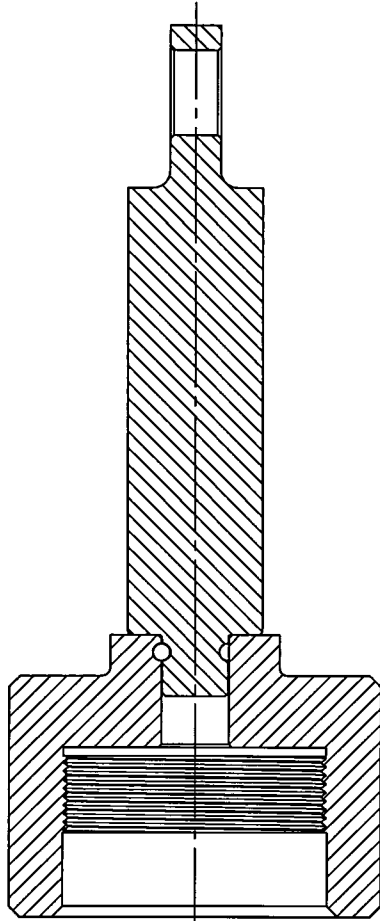
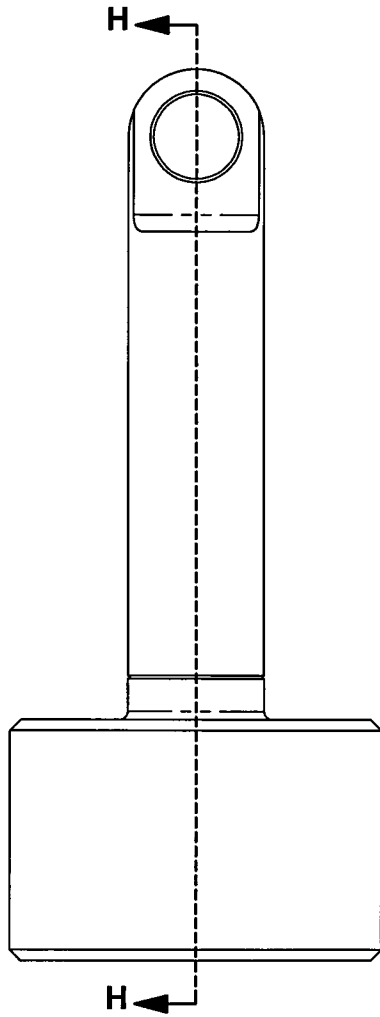
SECTION G-G



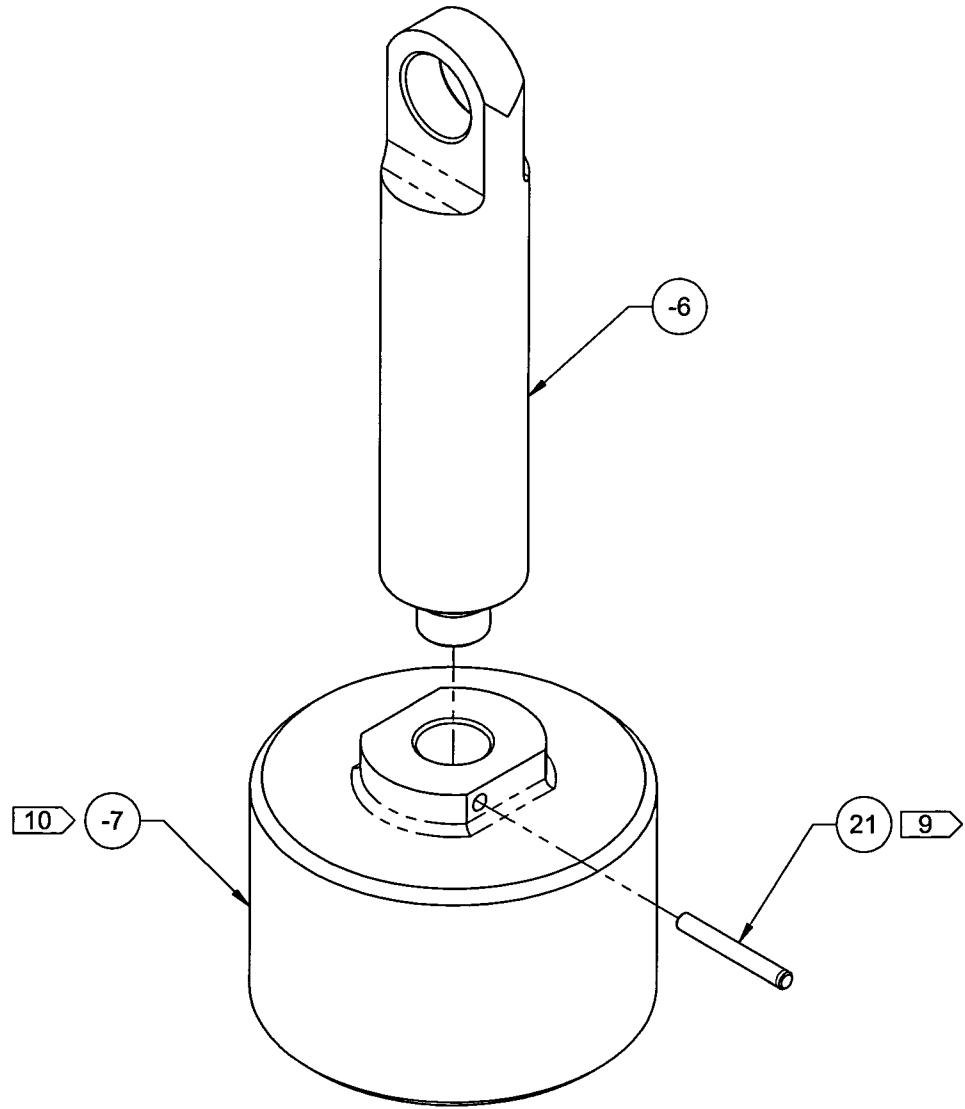
- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N "RB 92700-10301-041" AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 6 OF 16
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE 10/24/2018		PULLER ASSEMBLY	NTS
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ITEM #	QTY	PART #	PART TITLE
-6	1	RB 92700-10301-041-6	PUSHER PIN
-7	1	RB 92700-10301-041-7	PUSHER BASE
21	1	McMaster#97395A452 OR EQUIV.	SS DOWEL PIN 1/8" DIA. X 1" LG.



SECTION H-H

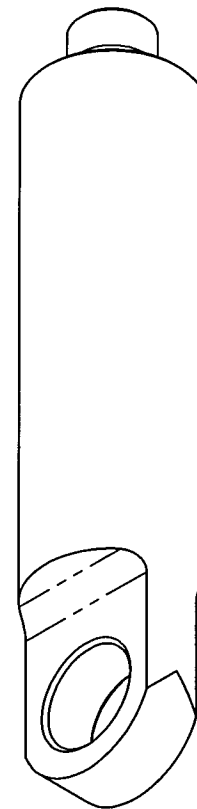
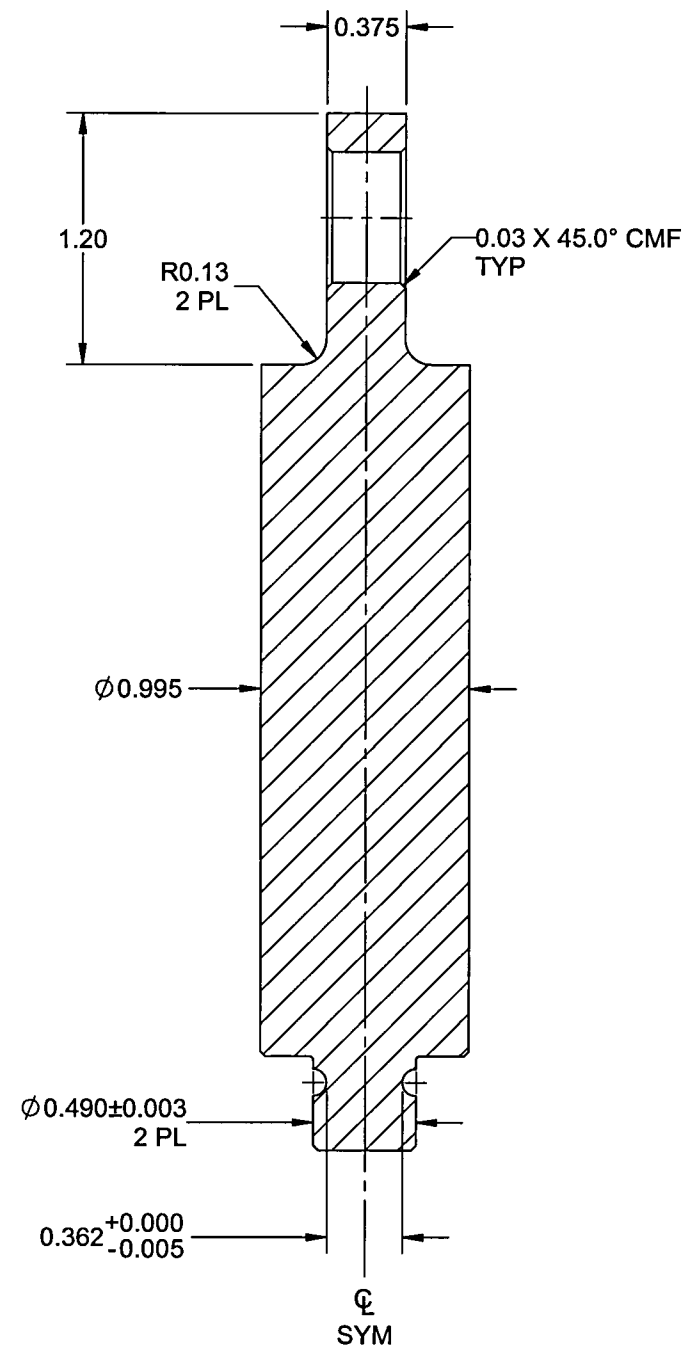
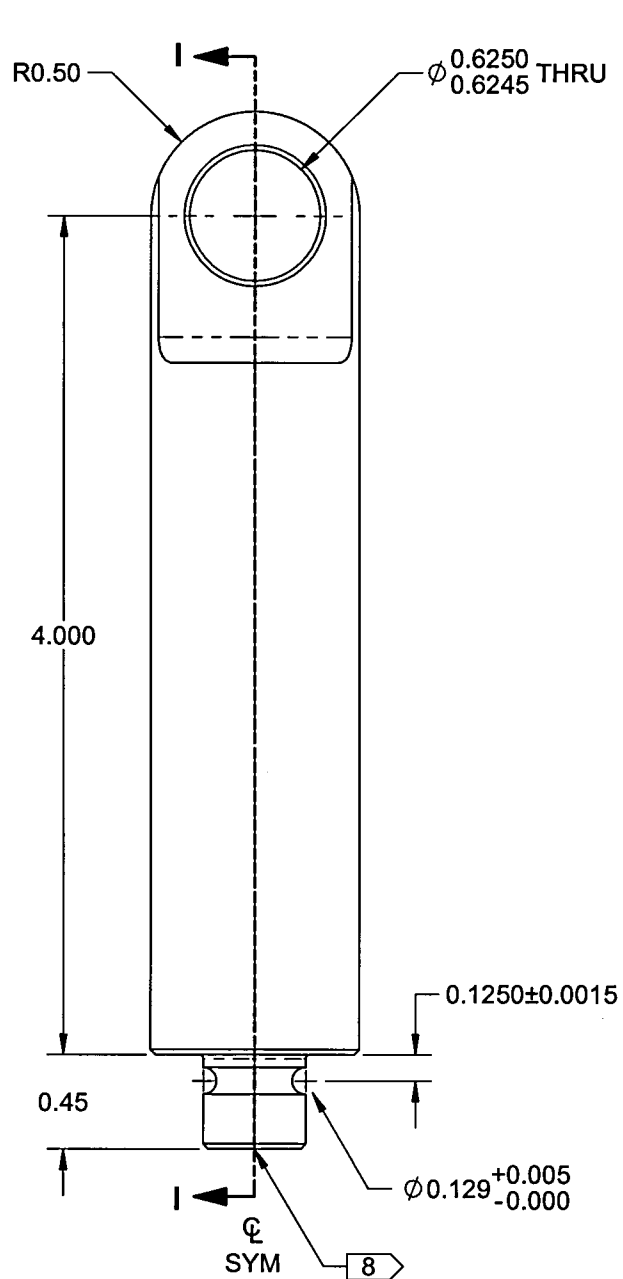


RB 92700-10301-041-5 PUSHER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 21 WITH ITEM -7 AND REMOVE EXCESS
- 10) ITEM -7 MUST ROTATE FREELY

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 7 OF 16
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE 10/24/2018		PULLER ASSEMBLY	NTS
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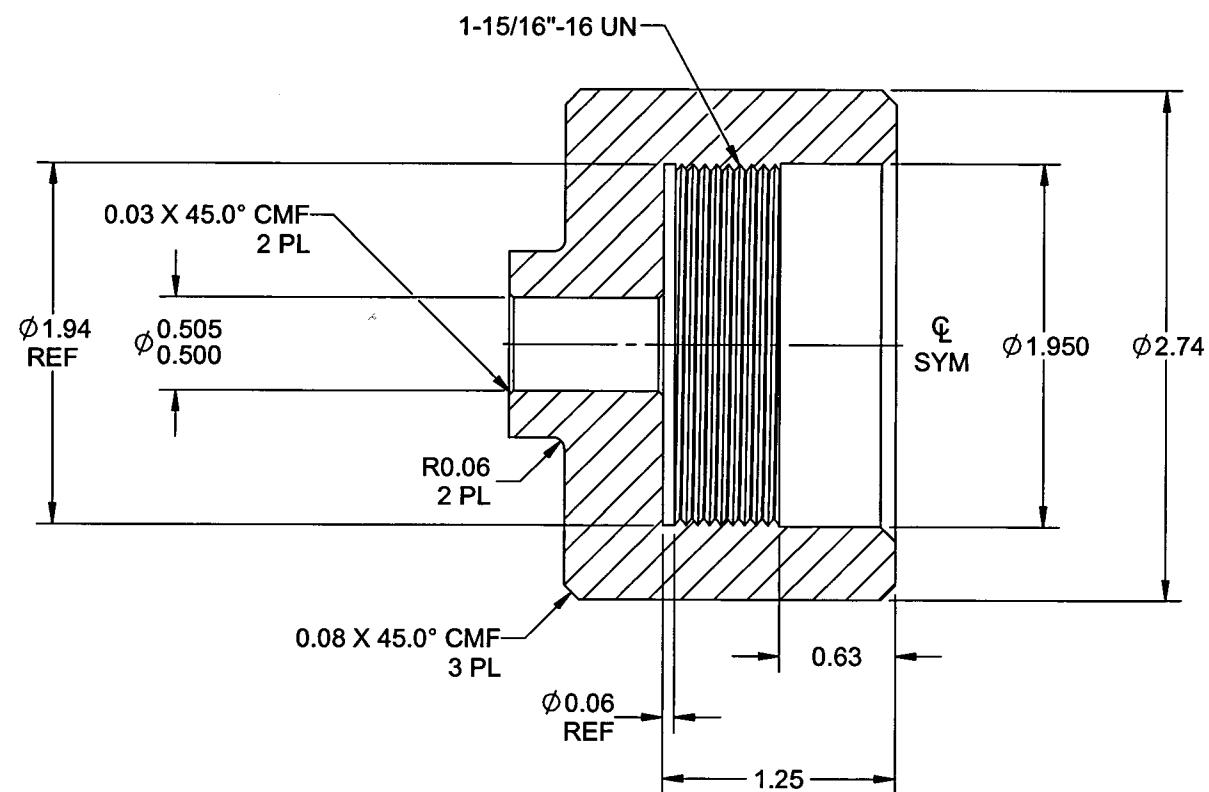
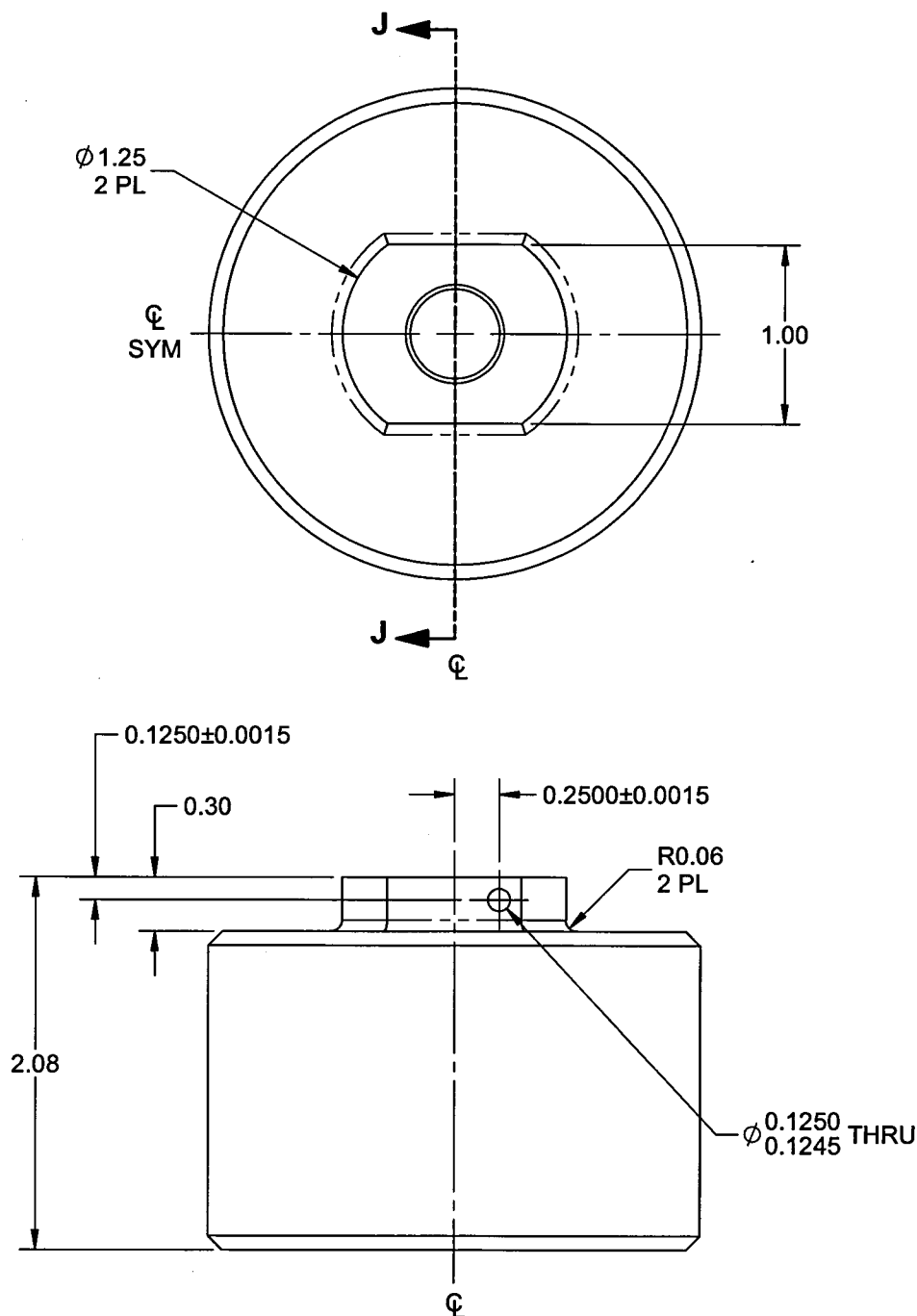


RB 92700-10301-041-6 PUSHER PIN

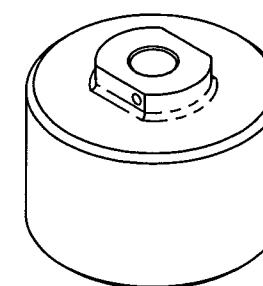
SECTION I-I

- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A
 - 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>ML</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 8 OF 16
APPROVED	<i>ML</i>	TITLE	SCALE
DATE 10/24/2018		PULLER ASSEMBLY	NTS
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SECTION J-J

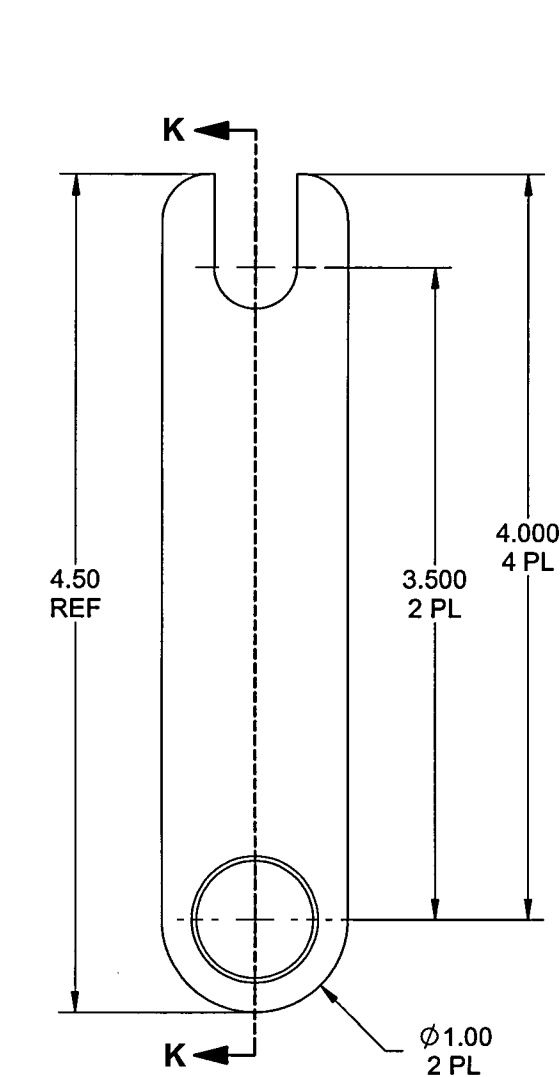


RB 92700-10301-041-7 PUSHER BASE

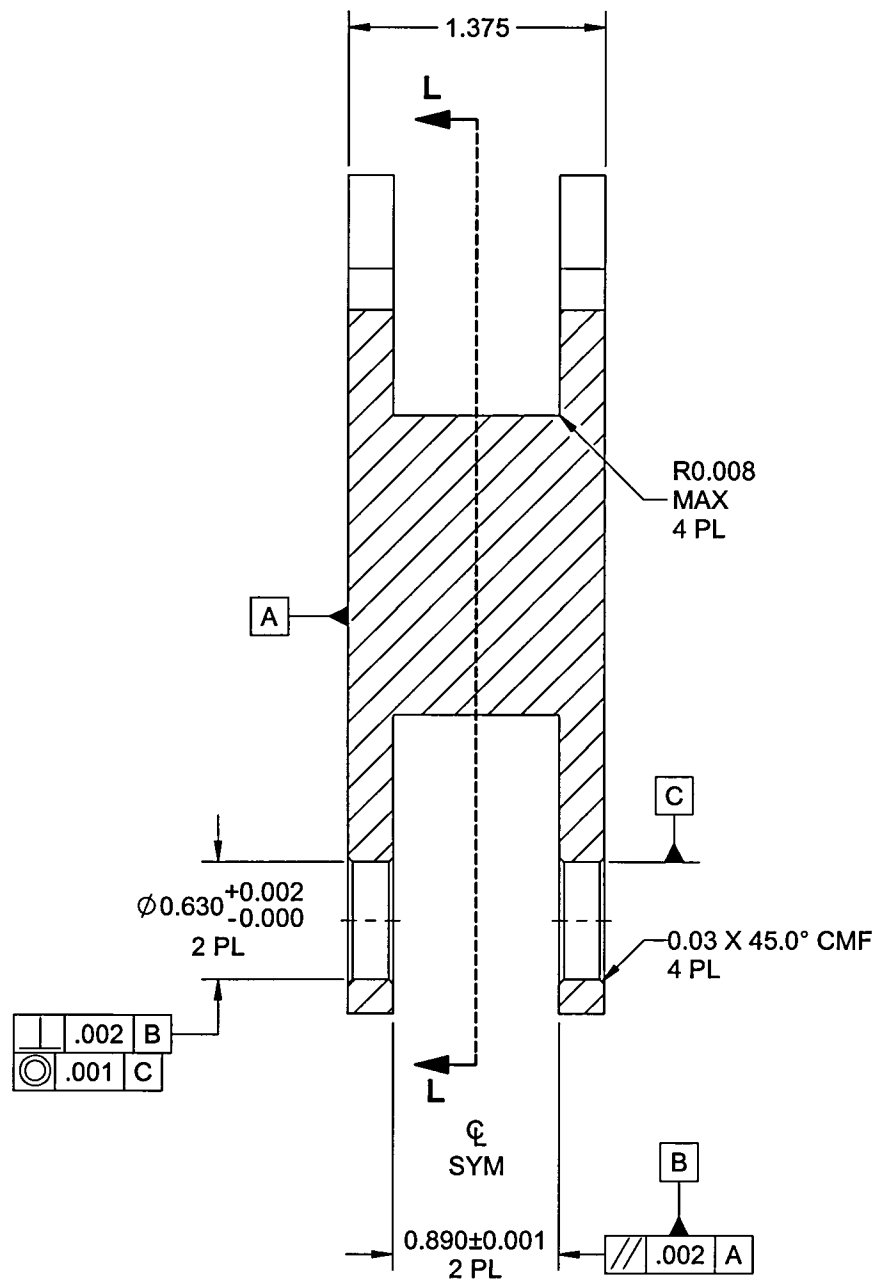
NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1/2/4 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = ± 0.1 / $\pm 1^\circ$
X.XX = ± 0.01 / $\pm 0.5^\circ$
X.XXX = ± 0.005 / $\pm 0.1^\circ$
X.XXXX = ± 0.0005 / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

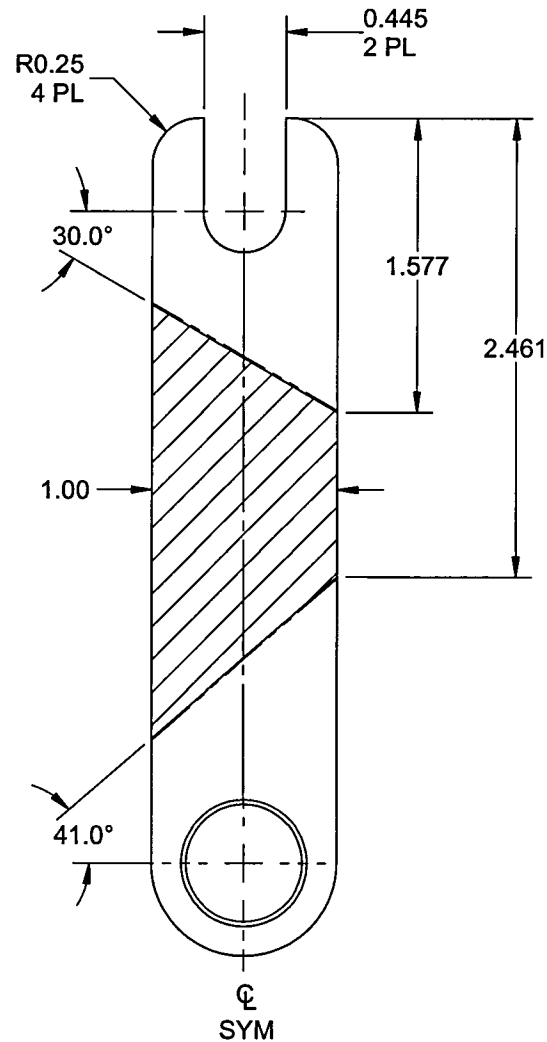
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>M. Lee</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 9 OF 16
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE 10/24/2018		PULLER ASSEMBLY	NTS
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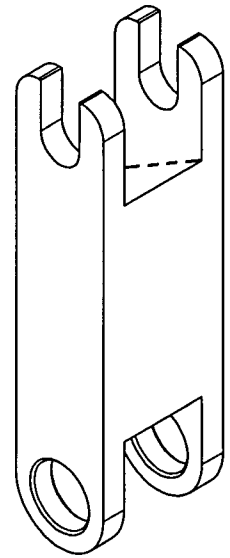
RB 92700-10301-041-8 LINKAGE 1



SECTION K-K



SECTION L-L



- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A
 - 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RB 92700-10301-041-8.STEP

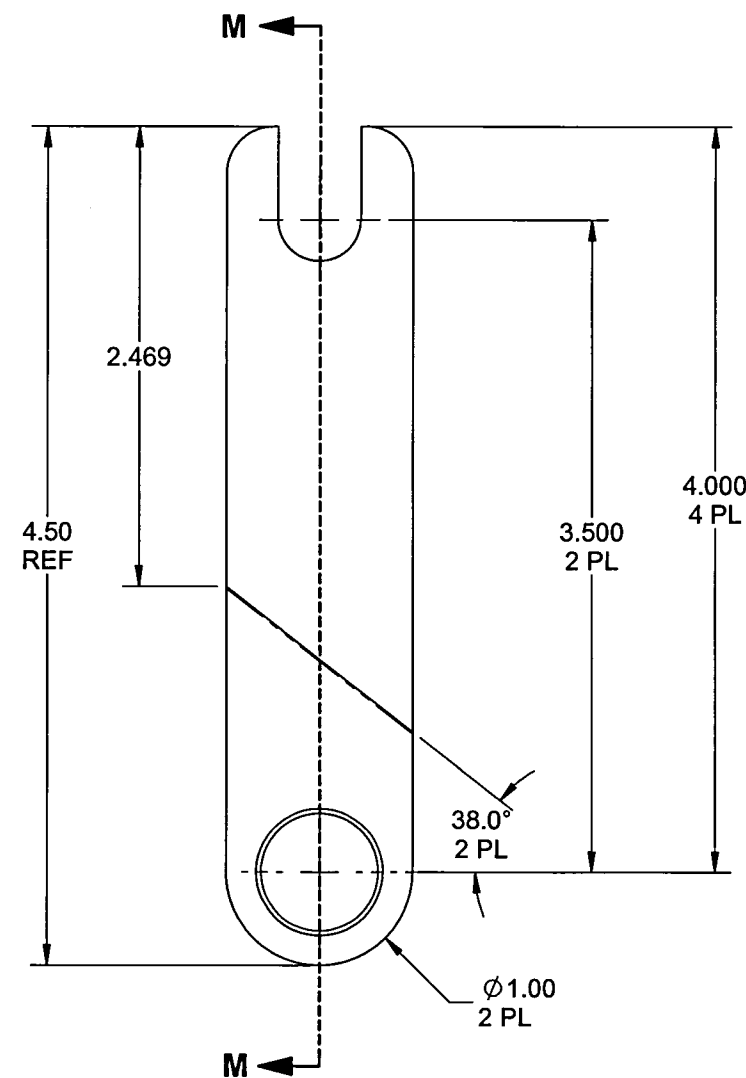
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>M. Lee</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 10 OF 16
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE 10/24/2018		PULLER ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

D

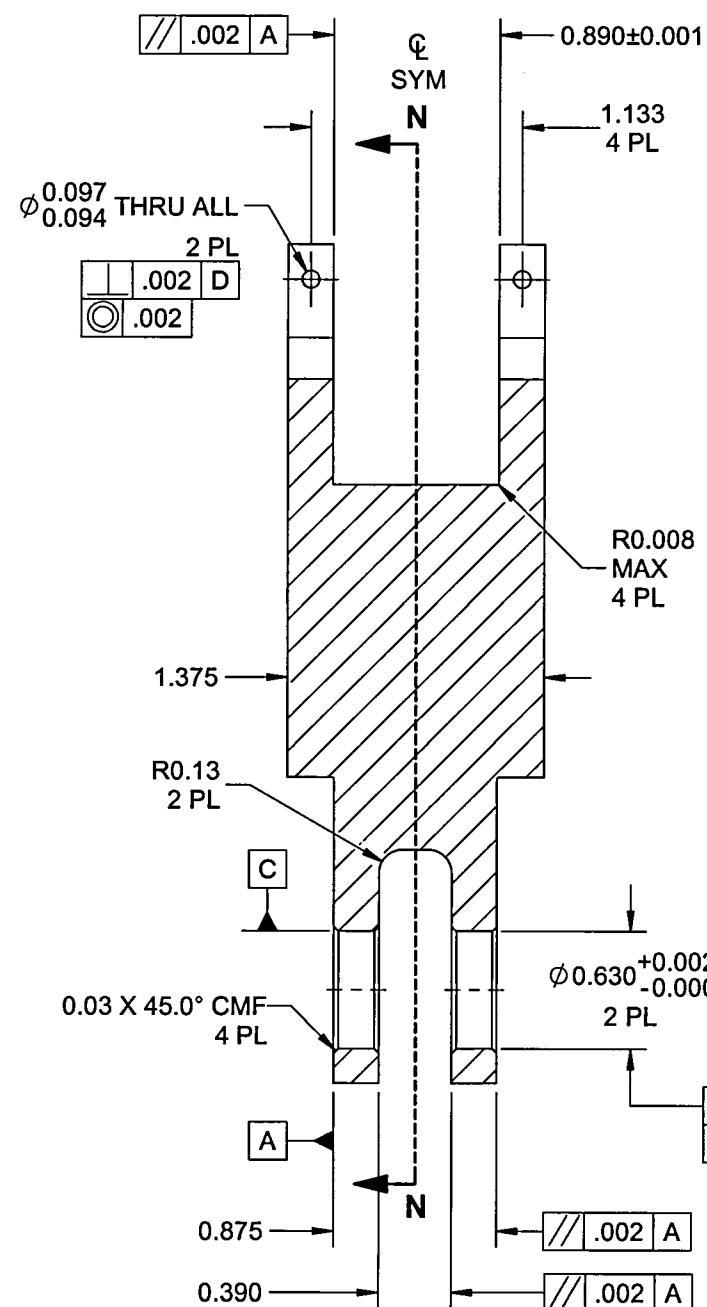
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B

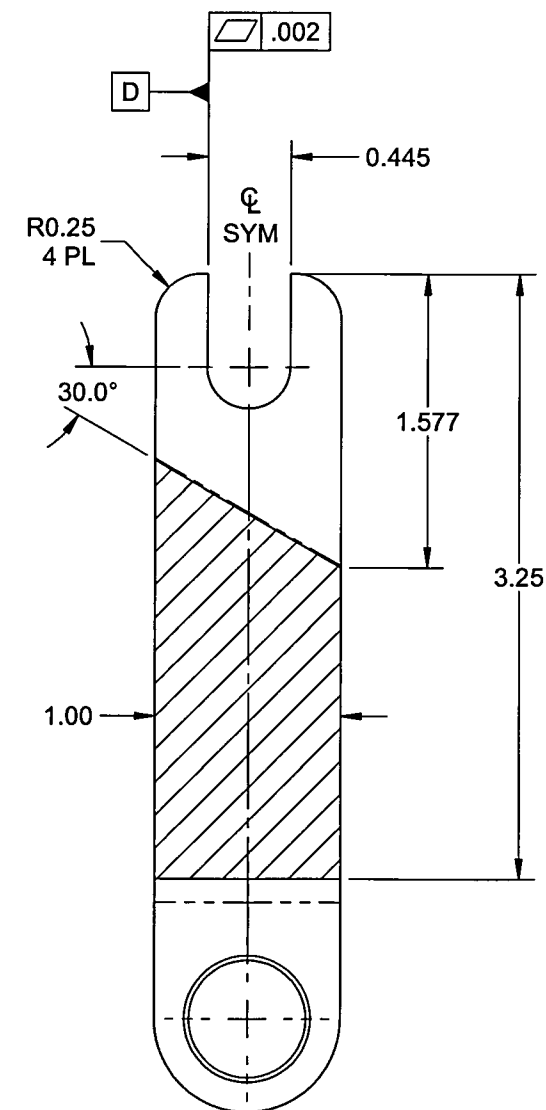


RB 92700-10301-041-9 LINKAGE 2

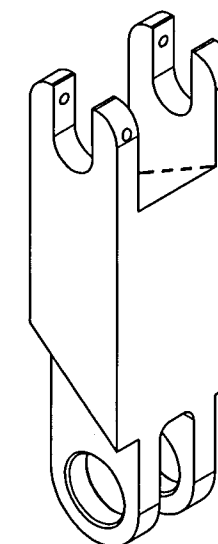
8



SECTION M-M



SECTION N-N



D

C

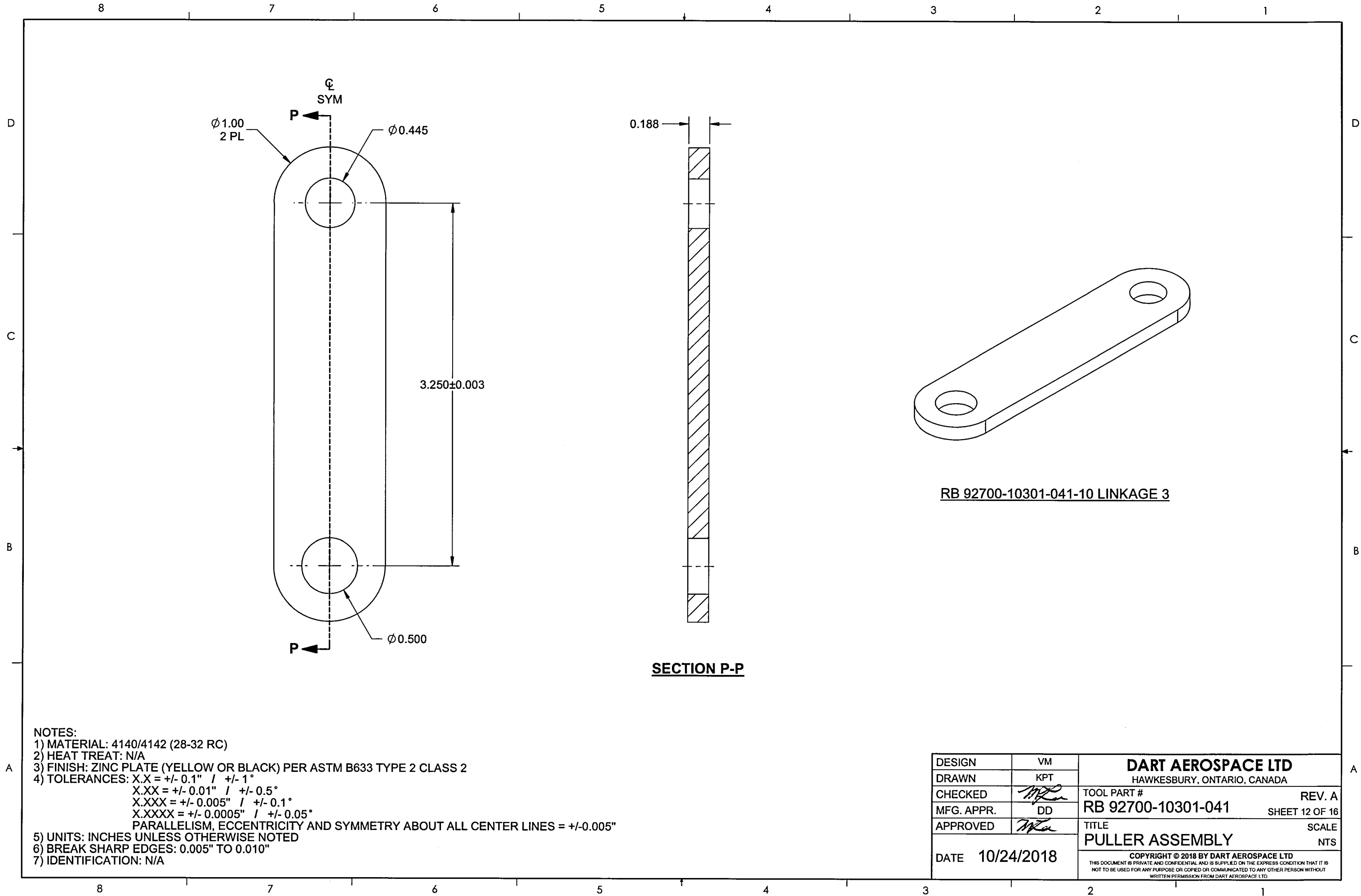
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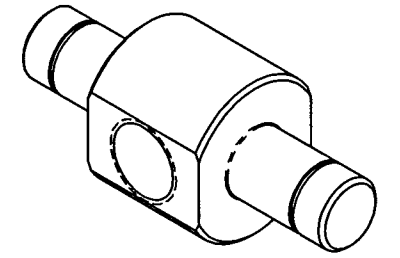
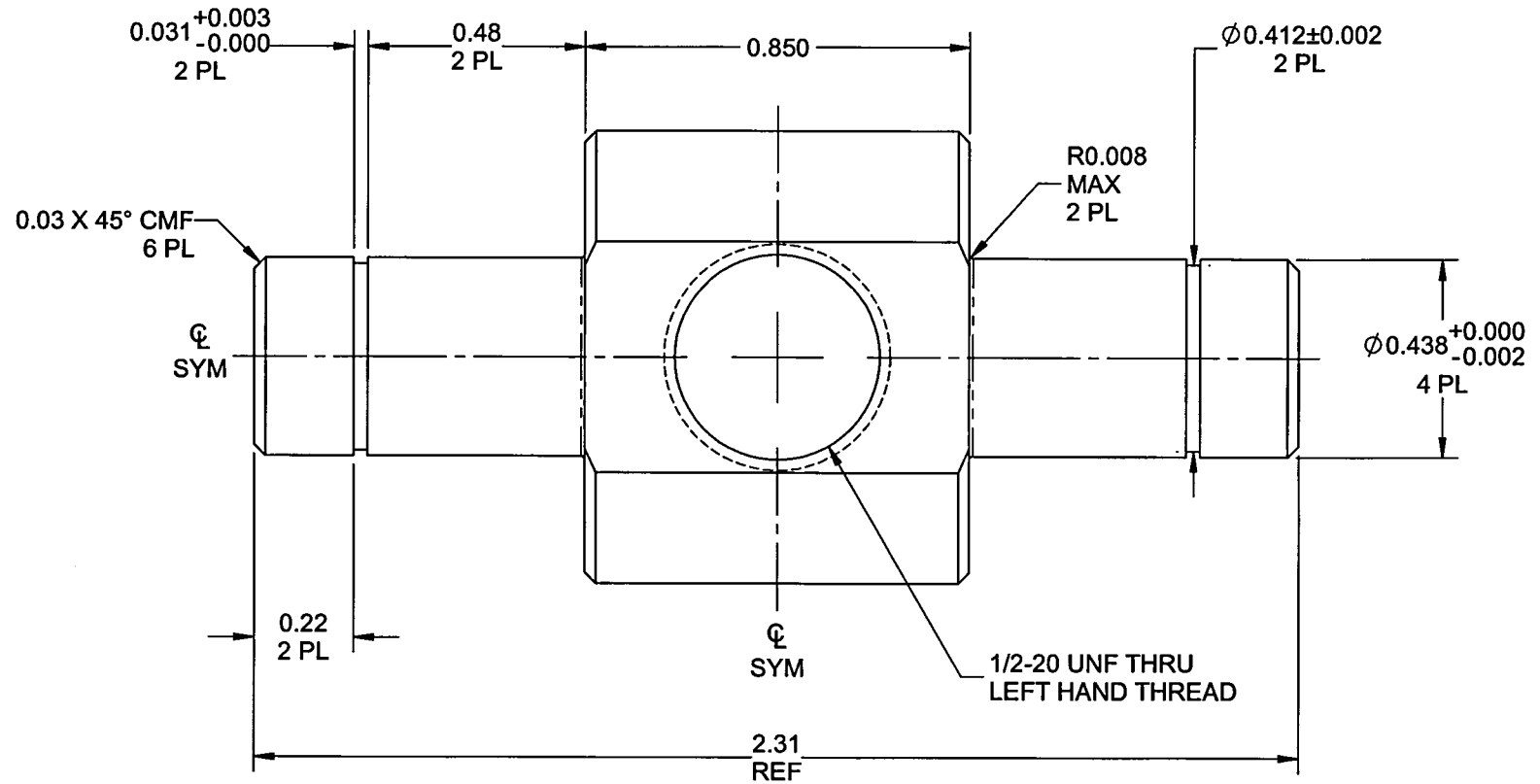
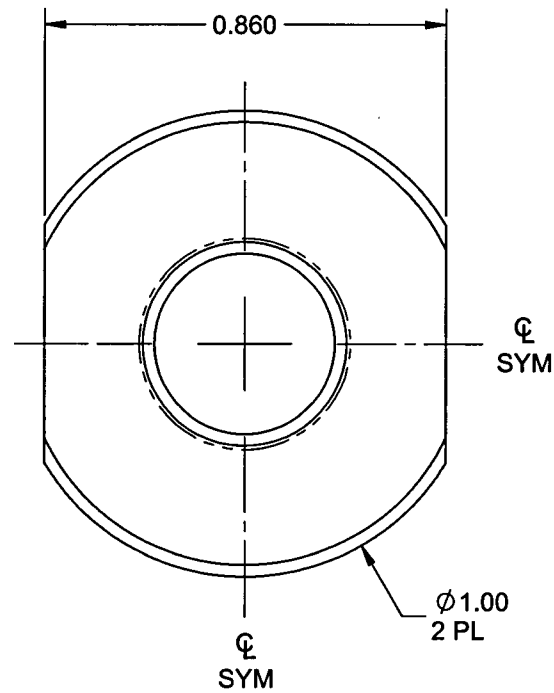
NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A
- 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF $\pm 0.005"$ PER CAD FILE RB 92700-10301-041-9.STEP

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>ML</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 11 OF 16
APPROVED	<i>ML</i>	TITLE	SCALE
DATE 10/24/2018		PULLER ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



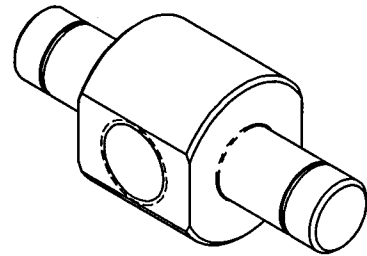
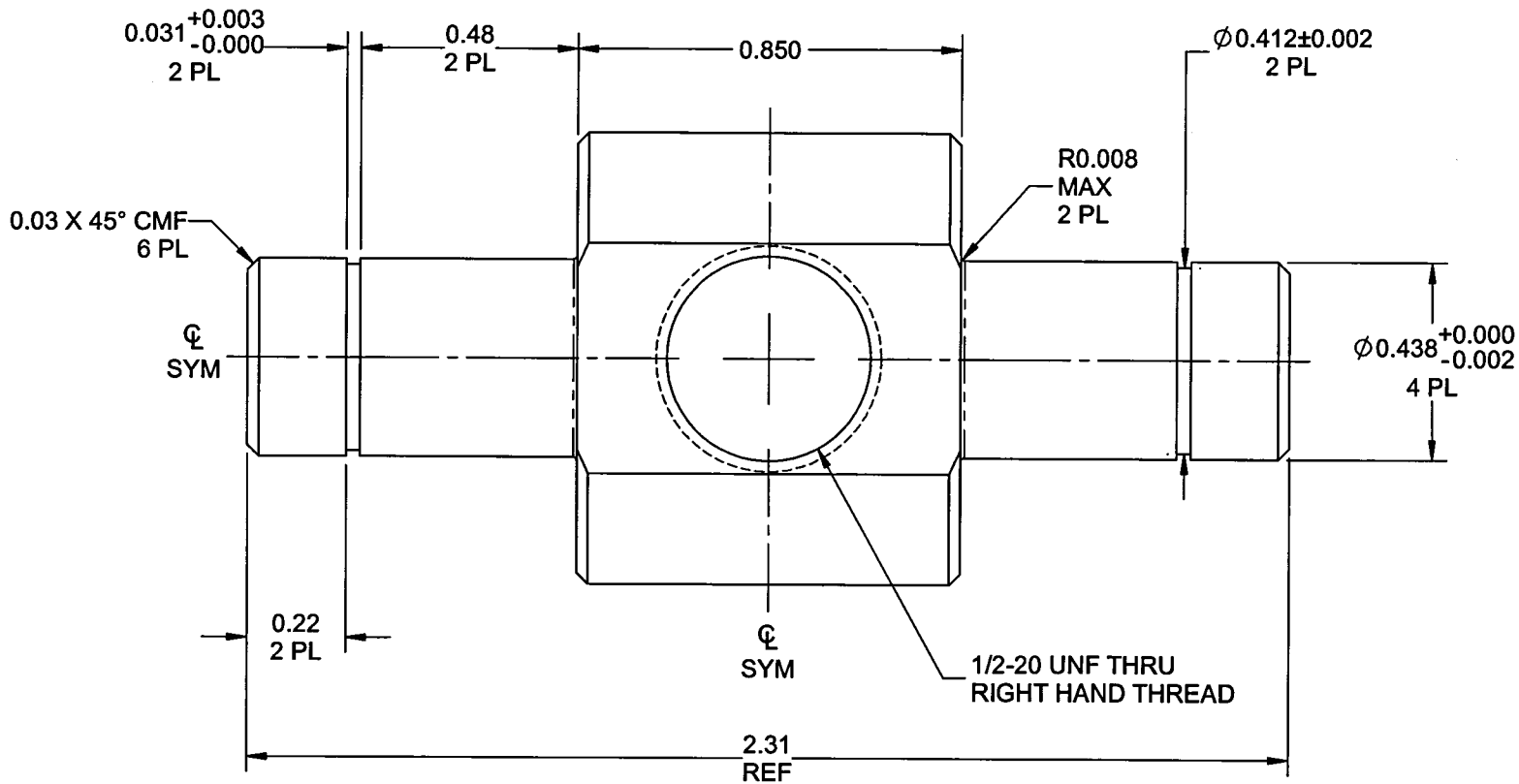
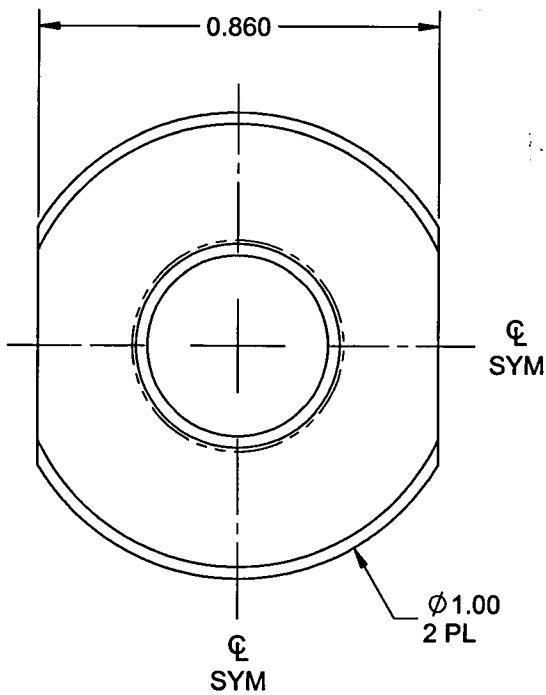


RB 92700-10301-041-11 LEFT HAND LINKAGE PIN

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

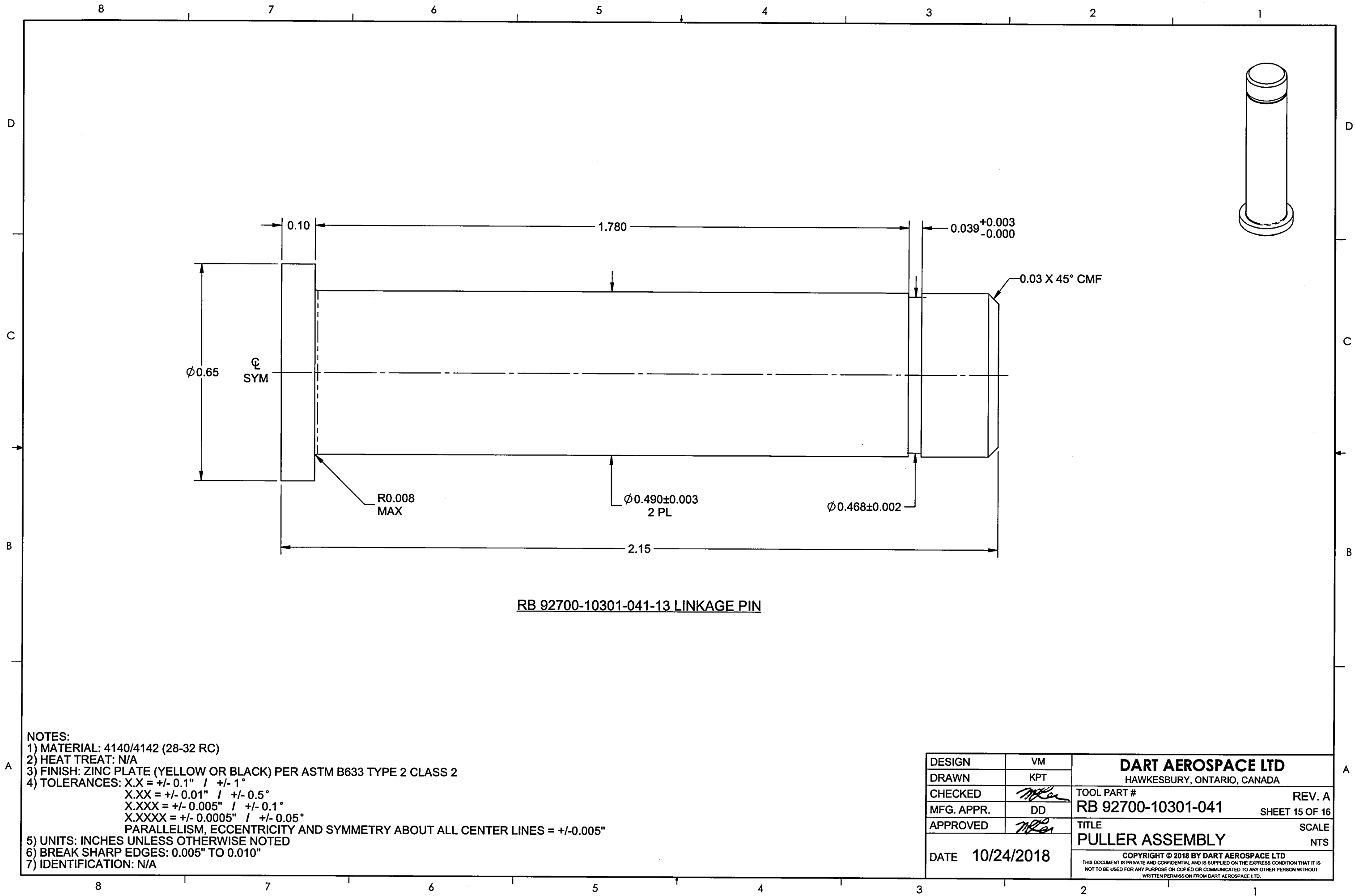
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>MR</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 13 OF 16
APPROVED	<i>MR</i>	TITLE	SCALE
DATE 10/24/2018		PULLER ASSEMBLY	NTS
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RB 92700-10301-041-12 RIGHT HAND LINKAGE PIN

- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>Mex</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 14 OF 16
APPROVED	<i>Mex</i>	TITLE	SCALE
DATE 10/24/2018		PULLER ASSEMBLY	NTS
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NOTES:

1) MATERIAL: 4140/4142 (28-32 RC)

2) HEAT TREAT: N/A

3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

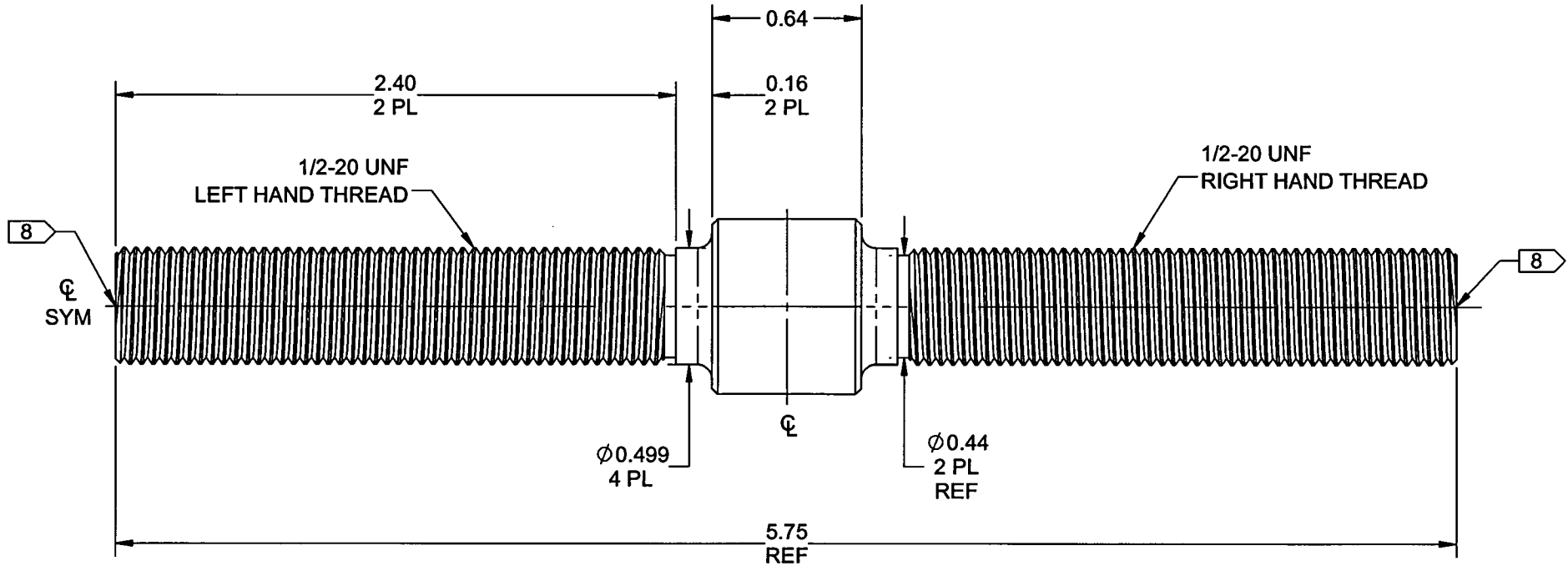
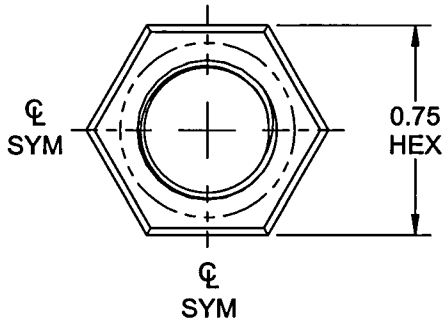
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 15 OF 16
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE 10/24/2018		PULLER ASSEMBLY	NTS
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RB 92700-10301-041-14 LINKAGE SCREW



NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	<i>[Signature]</i>	TOOL PART #	REV. A
MFG. APPR.	DD	RB 92700-10301-041	SHEET 16 OF 16
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE 10/24/2018		PULLER ASSEMBLY	NTS
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